



SLOVENSKI STANDARD

SIST EN 4025:2012

01-januar-2012

Nadomešča:

SIST EN 4025:2004

Aeronavtika - Cevni priključek 8° 30' iz titanove zlitine - Kotni cevni priključek 45° s pregrado

Aerospace series - Pipe coupling 8°30' in titanium alloy - Elbows 45°, bulkhead

Luft- und Raumfahrt - Rohrverschraubung 8°30' aus Titanlegierung - Winkel-Schottverschraubungen 45°

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Série aérospatiale - Système de raccordement 8°30' en alliage de titane - Raccords coudés à 45° pour traversée de cloison

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Ta slovenski standard je istoveten z: EN 4025:2010

ICS:

49.080

Letalski in vesoljski
hidravlični sistemi in deli

Aerospace fluid systems and
components

SIST EN 4025:2012

en,de

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 4025

October 2010

ICS 49.080

Supersedes EN 4025:2001

English Version

Aerospace series - Pipe coupling 8°30' in titanium alloy - Elbows 45°, bulkhead

Série aérospatiale - Système de raccordement 8°30' en
alliage de titane - Raccords coudés à 45° pour traversée de
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Titanlegierung - Winkel-Schottverschraubungen 45°

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: Avenue Marnix 17, B-1000 Brussels

EN 4025:2010 (E)**Foreword**

This document (EN 4025:2010) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has received the approval of the National Associations and the Official Services of the member countries of ASD, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2011, and conflicting national standards shall be withdrawn at the latest by April 2011.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 4025:2001.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

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EN 4025:2010 (E)**1 Scope**

This standard specifies the characteristics of elbows 45°, bulkhead, for pipe couplings 8°30', in titanium alloy, for aerospace applications.

Nominal pressure: up to 28 000 kPa.

Temperature range: – 55 °C to 135 °C.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 2424:2008, *Aerospace series — Marking of aerospace products*

EN 2491, *Aerospace series — Molybdenum disulphide dry lubricants — Coating methods*

EN 3267, *Aerospace series — Washers, bulkhead, in titanium alloy*

EN 3274:2010, *Aerospace series — Pipe coupling 8°30' — Thread end — Geometric configuration*

EN 3275:2002, *Aerospace series — Pipe coupling 8°30' up to 28 000 kPa — Dynamic beam seal — Metric series — Technical specification*

EN 3311, *Aerospace series — Titanium alloy TI-P64001 (Ti-6Al-4V) — Annealed — Bar for machining — $D < 110$ mm*

EN 3312, *Aerospace series — Titanium alloy TI-P64001 — Grade 2 — Annealed — Forgings — $D_e \leq 150$ mm¹⁾*

EN 3314, *Aerospace series — Titanium alloy TI-P64001 — Solution treated and aged — Bar for machining — $D \leq 75$ mm¹⁾*

EN 3315, *Aerospace series — Titanium alloy TI-P64001 — Solution treated and aged — Forgings — $D_e \leq 75$ mm¹⁾*

ISO 5855-3, *Aerospace — MJ threads — Part 3: Limit dimensions for fittings for fluid systems*

3 Required characteristics**3.1 Configuration — Dimensions — Mass**

According to Figure 1 and Table 1. The values apply before lubricating.

Dimensions not specified are at the manufacturer's option provided that the qualification and acceptance requirements of EN 3275:2002, type II are met.

3.2 Surface roughness

According to Figure 1, unless otherwise specified in the design documentation.

1) Published as ASD-STAN Prestandard at the date of publication of this standard by Aerospace and Defence Industries Association of Europe-Standardization (ASD-STAN) (www.asd-stan.org).

3.3 Materials

According to EN 3311 or EN 3314, EN 3312 or EN 3315.

3.4 Surface treatment

Lubrication: according to EN 2491, on threads and sealing faces.

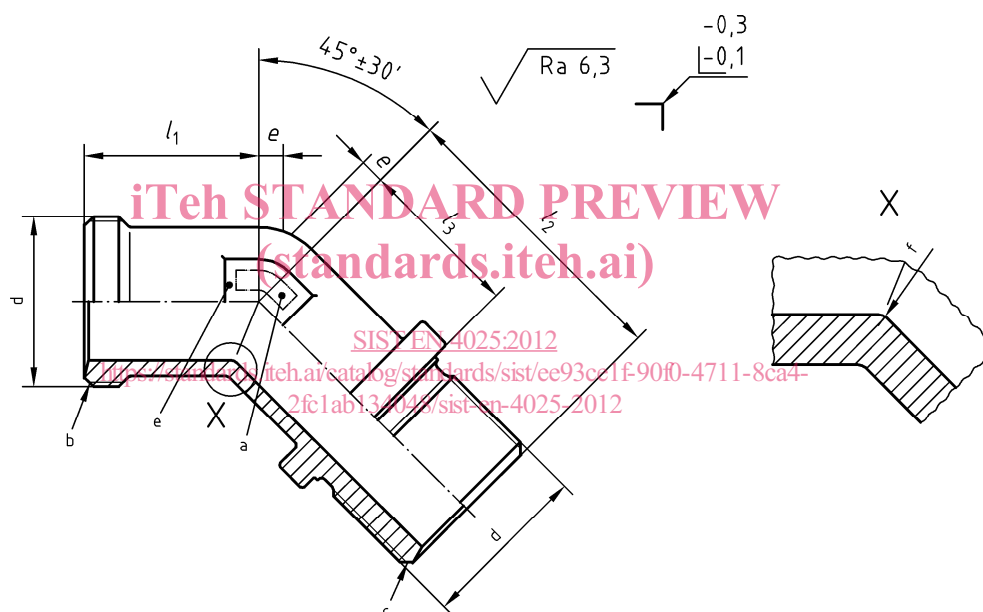
Prior to application of the lubricant, the surface shall be abrasive blasted using non-metallic grit.

Film thickness 0,005 mm to 0,013 mm.

3.5 Internal surface finishing

Finishing shall give a radius R of 0,3 mm to 1,0 mm and a surface roughness of 0,8 μm . Hand deburring is not permitted.

Dimensions in millimetres



- a Area for marking
- b According to EN 3274:2010, form C
- c According to EN 3274:2010, form D
- d Thread
- e Across flats s
- f Radius of the complete internal junction shall be between $R\ 0,3$ to $1,0$

Figure 1

Table 1

Dimensions in millimetres

Code ^a	Thread ^b	e^c	l_1^c	L_2^c	L_3	s^d	Mass g/piece max.
	4g6g		$\pm 0,2$	$\pm 0,2$	$\pm 0,2$	h13	
05	MJ10 \times 1	0,9	16,3	32,3	16,8	8	10,1
06	MJ12 \times 1,25	1,0	17,8	37,0	19,0	9	16,1
08	MJ14 \times 1,5	1,4	20,8	40,8	19,8	11	22,9
10	MJ16 \times 1,5	1,8	21,8	40,8	19,8	13	29,6
12	MJ18 \times 1,5	2,2	23,8	42,8	19,8	15	37,0
14	MJ20 \times 1,5	2,4	23,8	42,8	19,8	16	58,7
16	MJ22 \times 1,5	2,8	25,8	43,8	20,8	18	64,6
18	MJ24 \times 1,5	3,2	27,8	44,8	21,8	21	71,7
20	MJ27 \times 1,5	4,7	27,8	45,8	22,8	24	89,2
22	MJ30 \times 1,5	4,3	30,8	46,8	23,8	27	104,3
25	MJ33 \times 1,5	4,6	32,8	48,8	25,8	30	139,1
28	MJ36 \times 1,5	5,3	34,8	50,8	26,3	34	176,7
32	MJ39 \times 1,5	5,0	36,4	53,8	29,5	36	212,6

^a Corresponds to the pipe nominal outside diameter.

^b According to ISO 5855-3.

^c Drill depth dimension = $l_1 + e$ or $l_2 + e$.

^d Across flats.

4 Designation

EXAMPLE

Description block	Identity block
ELBOW 45°, BULKHEAD	EN4025-05

Number of this standard _____

Code (see Table 1) _____

NOTE If necessary, the code I9005 shall be placed between the description block and the identity block.

5 Marking

According to EN 2424:2008, style A and Figure 1.